Work Order January-30-14 11:.		74		*112	274	1 *						Page 1
Item ID: D3 Revision ID:	3536-35			Accept	*N	900	040	100)* s	etup Sta	17	S1*
Item Name: Ga	sket Aft									Sto	p *N	S2*
Start Date: 1/3	30/14 S	tart Qty: 8.00	*8*		Cu	st Item I	D:					
Required Date: 1/3	30/14 R	teq'd Qty: 8.00	*8*		Cu	stomer:						
Reference:								_		C4a	- 4	
Approvals: P	rocess Plan:	MLJ	Date: 14-01-31	Tooling:		Da	nte:		К	kun Sta	^ I \	R1*
	PC:		Date:	SPC (Y/N):		Da	nte:			Sto	, *V	R2*
Sequence ID/ Work Center ID		peration escription		Set Up/ Run Hours	Т	Cool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revisio	on Nbr										
D3536	Rev A											
100				0.00					_		`	
100	FI	OW WATER JET							8			JM14-02-20
Waterjet FLOW CNC Waterjet		Memo 1-Cut as per Deburr if ne	Dwg D3536 Dwg Rev:_cessary	0.00 AProg Rev:A	2-							; ;
110	Q	C2- Inspect parts off m	achine FAI/FAIB	0.00						•		
*11 0 *									8	_0		Jm 14-02-20
QC Quality Control		Memo		0.00								
				:	AS 27							
120	Q	C8- Inspect parts - seco	and check	0.00	9-89				C			
1 <i>2</i> 0				Julal	21				8			
QC		Memo		0.00	Ø)							

Quality Control

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE							TRAG	
QA Closed:	,		Date:			WORK ORDER NON-	-((JNFO	RIMANCE / UPDATE	W	ork Order up	odate only	٦	AEROSPACE
						DISPOSITION			AGAINS		PARTMENT	,		
Work Orde	er: -									_	- 1		7	
Part N	lo.					Rework Scrap			Skid-tube Crosstube Machining Small Fak		-1	Water Jet d. Eng. Coor.		Engineering Quality
NCR N	lo.					Use-as-is Suspected Unapproved		Therr	moforming Finishing Large Fab Composite	-	Rec/Sto	e/Packaging Supplier	_	Other
Root					Desci	ription of work order update	l	nitial	Action		Sign &		1	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification		QC Inspector
Design												•		
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material									1				1	
Operator							1						ļ	
Offset/Setup													-	
Process							ļ						1	
Supplier							١							
Training							1							
Transport													ı	
Unapproved				·										
							FA	ULT CA	TEGORY					·
Landi	ng G	Sear				General		,						
		Bending				Bend		Folio/I	Program		Outside Dim	ensions	□p	ressure/Forced
		Centre No	t Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	$\exists s$	et-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	n	٦т	emperature/Cure
		Crimp/Kir	k/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Unqualified		Part Lost/Mi	ssing	٦ν	Veld
		Cuffs				Contamination	-	1 .	tions Incomplete/Unclear		Part Moved		٦٧	Vrong Stock Pulled
		Crushing				Countersink		4	gned/off center	\vdash	Positioned V	<u> </u>	_	J
	-	Heat Trea	it			Cut Too Short		Mislab	-		Power Loss/		$\exists c$	Other
	\vdash	Inspection		Tube		Drawing	\Box	Misrea			⊸	· L		···
		Marks/Ch				Drill Holes		Off-set						
	Turning Sequence Finish				4	Calibration								
		Wave/Tw	-			Fit/Function		-	Sequence		_	· · · · · · · - · · · · · · · · · ·		

Work Ord				*112374*								Page
Item ID: Revision ID: Item Name:	D3536-35 Gasket Aft			Accept	*N900	<u>0</u> 40	100)*	Setup	Start Stop		S1* S2*
Start Date: Required Dat Reference:	1/30/14 e: 1/30/14	Start Qty: 8.00 Req'd Qty: 8.00	*8 *8		Cust Item :						1 1	
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N	R1*
Sequence ID/		Operation		Set Up/	Tool ID	Tool #	Plan	Accep	t Rej	ect :	^ I\] Reject	Hン [*] Insp.
Work Center 130 *120* Packaging	ID	Description Identify as per dwg & St	ock Location: FF	Run Hours 0.00			Code	Qty X	Qty	¢ :	Number JU	Stamp MG7

140

QC21- Final Inspection - Work Order Release

0.00

140

Quality Control

Packaging

Memo

0.00

MF MF (4-2-21

Page 2

DQA:			Date:											
						WORK ORDER NON-	CC	NFO	RMANCE / UP				AEROSPAC	U CE
QA Closed:			Date:							V	/ork Order u	odate only		
Work Orde	or.					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
Work Orac			<u>.</u>		_	Rework			Skid-tube	Crosstube	7	Water Jet	Engineering	7
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality	1
	•				_	Use-as-is		Therr	moforming	Finishing	Rec/Sto	re/Packaging	Other]
NCR N	No.		-			Suspected Unapproved			Large Fab	Composite		Supplier]
Root					Desci	ription of work order update	4	nitial	Actio		Sign &			
Cause		Date	Step	Qty		or non-conformance		ief Eng			Date	Verification	QC Inspector	ŗ
Design						<u> </u>				·				
Doc/Data														
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Material									ļ					
Operator			<u>'</u>						1					
Offset/Setup														
Process														
Supplier				·										
Training														
Transport														
Unapproved		<u> </u>							<u> </u>			<u> </u>		
						· · · · · · · · · · · · · · · · · · ·	FA	ULT CA	TEGORY					
Landi	ng (Gear			_	General					_	-	_	
		Bending			<u> </u>	Bend		1	Program		Outside Din	⊢	Pressure/Forced	
		Centre No	ot Concer	ntric	_	BOM/Route	_	Grain			Over/Under		Set-up	
		Cracks			\perp	Broken/Damage/Defect		Hardwa	•	_	Part Incorre	ļ	Temperature/Cure	e
		Crimp/Kit	nk/Ripple	/Wave	_	Burrs		1	tion Incomplete/Und	· –	Part Lost/M	_	Weld	
	_	Cuffs				Contamination		1	tions Incomplete/Ui	nclear	Part Moved	-	Wrong Stock Pulle	ed
		Crushing			<u>_</u>	Countersink	L	1	gned/off center	<u> </u>	Positioned		,	
	L	Heat Trea			<u> </u>	Cut Too Short	├─	Mislab		L	Power Loss,	/Surge	Other	
		Inspectio	-	Tube	<u> </u>	Drawing	<u> </u>	Misrea						
	<u>_</u>	Marks/Ch			_	Drill Holes	_	Off-set						
		Turning S				Finish		1	Calibration					
	Wave/Twist in Tube Fit/Function			Out of	Sequence									

January-30-14 11:38:05 AM

Work Order ID:

112374

Parent Item:

D3536-35

Parent Item Name:

Gasket Aft

Start Date: 1/30/14

Required Date: 1/30/14

Start Oty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 NEOPRENE SHEET 0.06	3	Purchased	No			100	sf	44.1000	0.6197	5-5084448	}	Jm	14-02-20
				Location		Loc Qty	Lo	c Code					

44.1

44.1

128266

M126546

MAT052

128266

DQA:			Date:		*									
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	r:					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		
i						Rework			Skid-tube Crosstube	Г]	Water Jet		Engineering
Part N	о.					Scrap		!	Machining Small Fab	⊢	Pro	d. Eng. Coor.		Quality
	_					Use-as-is		Thern	noforming Finishing		Rec/Stoi	re/Packaging		Other
NCR N	o					Suspected Unapproved			Large Fab Composite]	Supplier		
											1			
Root	Ì				Desc	ription of work order update		nitial	Action		Sign &		1	
Cause	_	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	\sqcup	QC Inspector
Design									·					
Doc/Data	4												١	
Equip/Tooling	4												ı	
Handling/Pre	4													
Material	4						ļ				,		1	
Operator	4					1								
Offset/Setup	긕													
Process	4								1					
Supplier	4													
Training	_												l	
Transport	_		!											
Unapproved						· · · · · · · · · · · · · · · · · · ·								
			· · · · · · · · · · · · · · · · · · ·				FA	ULT CA	TEGORY					
Landin					_	General		1	_	_	1			
	_	Bending				Bend	Ь	1	Program	L	Outside Dim	-	_	Pressure/Forced
	\neg	Centre No	ot Concer	ntric		BOM/Route		Grain		L	Over/Under	-	_	Set-up
	_	Cracks			<u> </u>	Broken/Damage/Defect		Hardwa		<u> </u>	Part Incorre	⊢		Temperature/Cure
	_	Crimp/Kir	nk/Ripple	/Wave	\vdash	Burrs	<u> </u>	1 '	ion Incomplete/Unqualified	_	Part Lost/Mi	ssing	-	Weld
	-	Cuffs				Contamination	\vdash	4	tions Incomplete/Unclear	<u> </u>	Part Moved	L		Wrong Stock Pulled
	_	Crushing			<u> </u>	Countersink		• •	gned/off center	<u> </u>	Positioned V	, ,		
}	_	Heat Trea			<u> </u>	Cut Too Short	L	Mislabe		L	Power Loss/	Surge		Other
	-	Inspection	-	Tube	<u> </u>	Drawing	<u>_</u>	Misrea						
	_	Marks/Ch			<u> </u>	Drill Holes	<u></u>	Off-set						
	_	Turning S			<u> </u>	Finish	_	-	Calibration					
		Wave/Tw	ist in Tub	oe e		Fit/Function		Out of	Sequence					

DART AEROSPACE LTD	Work Order:	112374
Description: Gasket	Part Number:	D3536-35
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.25	+/-0.030	23.25"			+	Jamo 6
19.75	+/-0.030	19.75	_		7	
17.75	+/-0.030	17.75	-		T	
14.25	+/-0.030	14.25	_	_	T	
9.50	+/-0.030	9.50"	-		T	
4.75	+/-0.030	4.75	-		V	
2.00	+/-0.030	2.00	-		V	
6.00	+/-0.030	6.000	-		V	
6.75	+/-0.030	(0-75	_		V	
0.30	+/-0.030	0.30"	_		V	
0.30	+/-0.030	0.30	_		V	
1.89	+/-0.030	1.89	_		V	
Ø0.19	+0.005/-0.001	0.19"	_		V	
0.063	+/-0.010	0.060"	_		ν	
				۸.		

Measured by: Jm	Audit	ed by:	PM?	Prototype Approval:	N/A
Date: 14-09	- 3 °	Date: 14		Date:	N/A

Rev	Date	Change	Revised by	Approved
_ A	07.03.14	New Issue	KJ/JLM	

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26.65 -17.65 -13.40 -- 0.90 - 5.65 1.89 DETAIL A 3.90 #0.19 (TYP 3 PLS)

D3536-11 GASKET



112374 MC5 1401-31



CHECKED

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DRAWING NO.

SHEET

SCALE 아 6

1:10

B

(**P**)

DART

AEROSPACE PORT HADLOCK,

USA,

NC.

06. PATE

5 25

GASKET

 \triangleright

06.10.25

NEW ISSUE

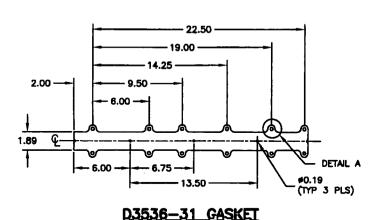
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-	· · · · · · · · · · · · · · · · · · ·	- 29.40			
		<u> </u>			
	<u> </u>	23.	90		
	-		 18.98		
		-	14.07		
			9.15		0.90
				5.65 —	
					1
Q POST					1.89
	~				
DETAIL A-			8.00	3.90	- '
#0.19/ (TYP 4 PLS)			- 14.00	-	
(TYP 4 PLS)	-	20.00		4	

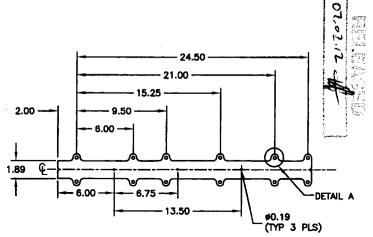
D3536-13 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- PART IS SYMMETRICAL ABOUT &
 TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. 33.92 28.53 -23.14 -17.75 14.25 -DETAIL A 2.00 1.89 - 6.00 ME 06.10.25 CHECKED 0.90 - 16.00 **d**0.19 (TYP 6 PLS) 24.00 32.00 3 b 39.00 48.00 D3536-23 GASKET GASKET D3536 DRAWING NO. DART 21.80 1.45 16.35 DETAIL A AEROSPACE PORT HADLOCK, 10.90 R0.06 (TYP) 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063) 2) FINISH: NONE TOTAL
 TOTAL 1.89 R_{0.25} TOOLING NOTCH - 6.00 (TYP) 5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER PURPOSE (TYP 3 PLS) **L** 7) SEE PAGE 6 FOR DETAILS AND SECTION D3536-25 GASKET SHEET 욹 **₹** COPIED U REV. SCALE 유 1:10





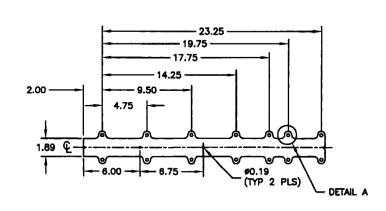
D3536-33 GASKET



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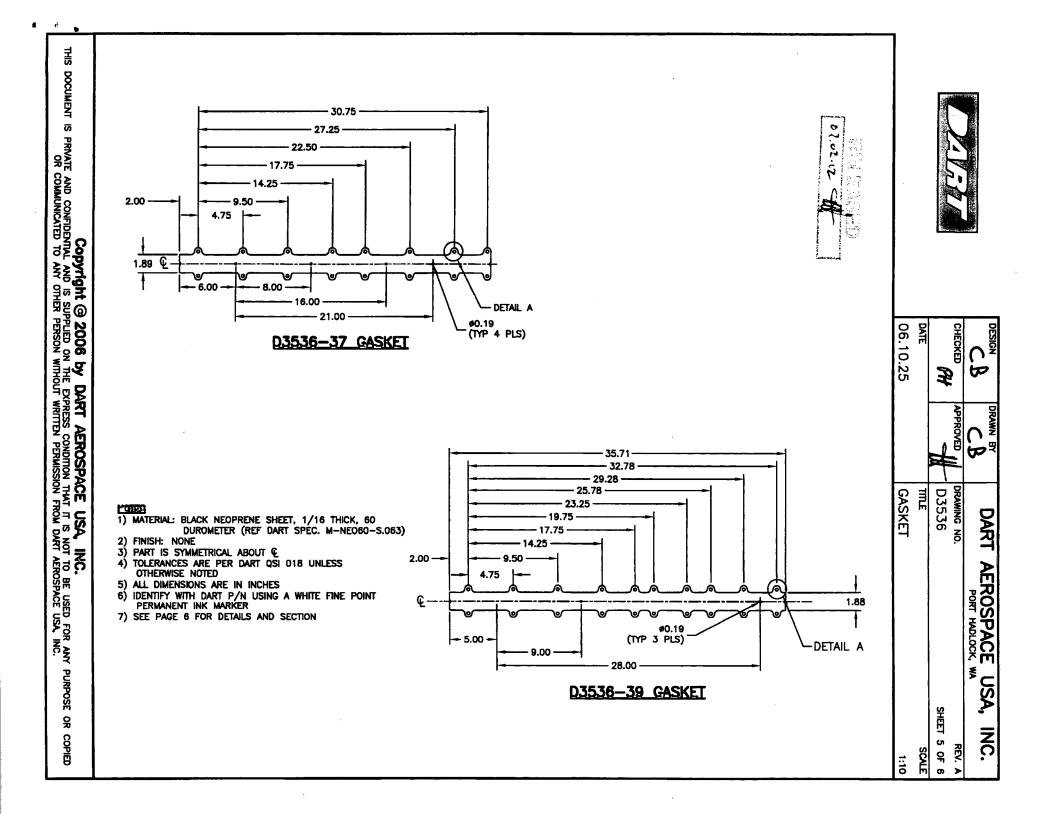
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE 3) PART IS SYMM

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-35 GASKET

C B	CB	DART AEROSI	AEROSPACE USA, INC.
CHECKED	APPROVED #	DRAWING NO.	REV. A
770	Na Para	D3536	SHEET 4 OF 6
DATE		JUITE 3_UIT	SCALE
06.10.25		GASKET	1:10



- 27.98 -25.08 18.50 -15.00 2.00 -1.88 4.00 #0.19 (TYP 2 PLS) DETAIL A



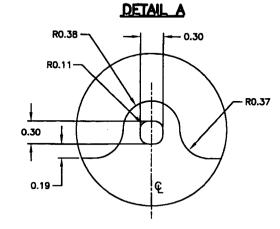


06. 1	DATE	

D3536-41 GASKET

- TOTES

 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
 DUROMETER (REF DART SPEC. M-NEO60-S.083)
- 2) FINISH: NONE 3) PART IS SYMM
- PART IS SYMMETRICAL ABOUT ©
 TOLERANCES ARE PER DART QSI 018 UNLESS
 OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



CB	CB	DART AEROSPACE USA, INC.	NC.
CHECKED	APPROVED //	DRAWING NO.	REV. A
M	#	D3536 SHEET	SHEET 6 OF 6
DATE		TIME	SCALE
06.10.25		GASKET	1:10